

Process Sheet

SP 07/03/30

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	D34773	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-3	Tube	B 22567 31403

20	D34771	Flange
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-1	Flange	134295

3.0	D34775	BLOWER ADAPTER FLANGE
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-5	Flange	13 31276

40 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3477

2-Spot Weld as per Dwg D3477 and Dart QSI 004

SB 07/03/30

67-03-3 U

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR INLET ADAPTER

Job Number: 31258

Part Number: D3477041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

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①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

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①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: GA

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①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

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①

Job Completion



u 07.03.30



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. A
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SHEET 1 OF 4
A	05.12.09	NEW ISSUE	SCALE 1:2

[Signature] 06.04.03

D3477-5 BLOWER
ADAPTER FLANGE (1)

D3477-3
TUBE (1)

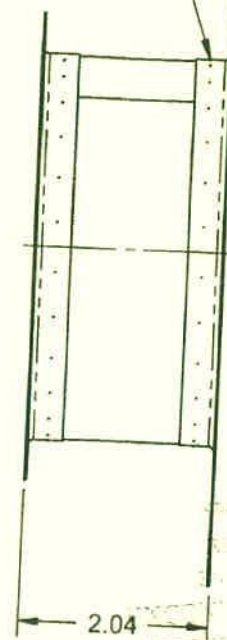
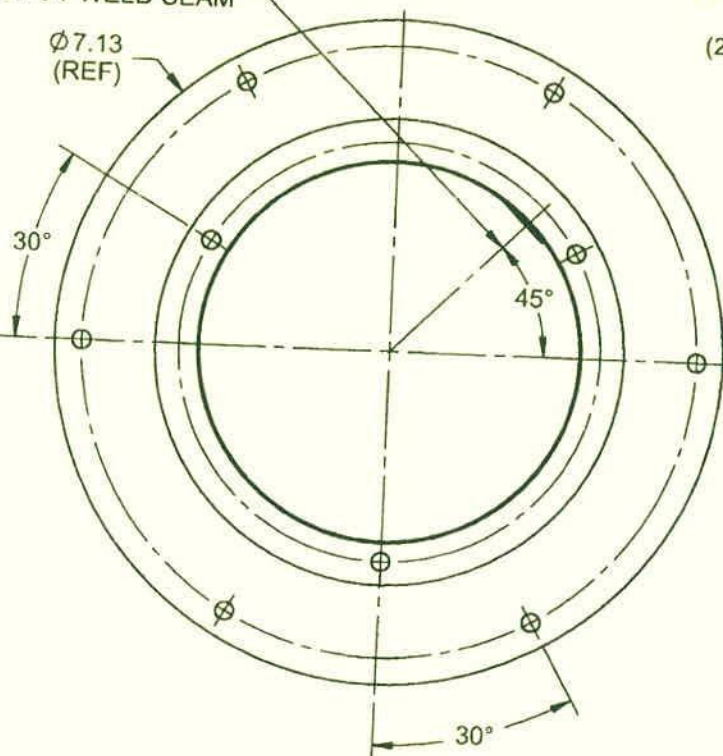
D3477-1
FLANGE (1)

ALIGNMENT OF
SPOT WELD SEAM

Ø 7.13
(REF)

(2 PLACES)

0.50
(24)



D3477-041 BLOWER MOTOR INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO: 4

EMPLOYEE: Milena Cantel

PART NUMBER: D 3477-041

JOB NUMBER: B 31258

MATERIAL TYPE: 504

MATERIAL THICKNESS: 1.20

GROUP SPECIFICATION: SS

Group 1: Aluminum & magnesium

Group 2: Iron; nickel; cobalt

Group 3: Titanium

TEST RESULTS

PASS FAIL

VISUAL:

[☒] [] []

PENETRATION:

[☒] [] []

PULL STRENGTH:

[☒] [] []

PSI Reading: _____

The individual named above has been trained and is qualified in accordance with standard AMS-W-6858A, and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/03/30

QUALIFIER: SB

